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(71) Applicants  
Moplefan S.p.A.,  
31, Foro Buonaparte,  
Milan,  
Italy.

(72) Inventors  
Alfredo Gemmi  
Francesco Protospataro

(74) Agents  
I.P.P. Services

(54) Process for the preparation of  
thermoweldable polyolefinic films

(57) Non-fibrillating thermo-weldable  
films are made from two layers of the  
same polyolefinic material, following a  
sequence of operations essentially  
comprising the extrusion of a base film,  
cooling and longitudinally stretching it  
under defined conditions, extruding a  
relatively thin coating of the same  
polyolefinic material onto the base film  
and then transversely stretching the  
composite film under defined condi-  
tions. Typically, an extruded film of  
isotactic polypropylene is cooled to  
40°C., stretched 1:5, coated at a base/  
coat ratio of 8:1 and stretched trans-  
versely 1:8. The polyolefinic material  
should be a crystalline alpha-olefine  
polymer or copolymer or a mixture of  
such.

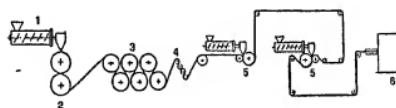


Fig. 1

GB 2 024 715 A

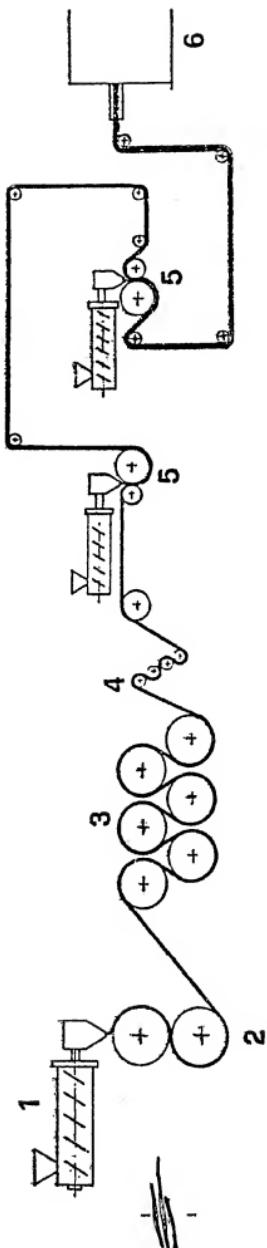


Fig. 1

**SPECIFICATION****Process for the preparation of thermoweldable polyolefinic films**

5 The present invention concerns a method for the preparation of thermoweldable, non-fibrillating polyolefine films obtained from a single type of olefinic polymer or copolymer or from mixtures thereof, by the combination of a plurality of successive extrusions and suitable drawing operations. 5

It is an object of the invention to provide, in a convenient manner, films suitable for the manufacture of containers, covers, small bags, vessels and in general manufactured articles intended for the packaging 10 industry.

As is known, materials intended for packaging should possess a combination of characteristics, both mechanical as well as aesthetic, and in particular impermeability to gases and vapours, of thermoweldability, transparency and brightness and many other characteristics that are difficult to establish simultaneously in films obtained from a single type of polymer. Thus, recourse is made to the use of laminated sheets and 15 coated films obtained by combining polymers of different types. 15

There are also known and described in various of our patents, laminated and bonded films comprising polyolefinic films and films of other theroplastic polymers or metal foils, in particular of aluminium.

There are also known bonded sheets obtained from non-stretched polyolefinic films and from films of other thermoplastic polymers which are successively stretched, and also films obtained by the extrusion of 20 olefinic polymers onto films of other thermoplastic polymers. 20

It has now been found that it is possible to obtain thermoweldable and non-fibrillating polyolefinic films by a process which involves extruding on a polyolefine base film a polyolefine composition which is the same as that of the base film and effecting certain suitable stretch operations. 25

Thus, the process of the invention permits the use of the same polymer composition both for the preparation of the base film and for its coating. 25

The invention consists in a process for the preparation of thermoweldable and non-fibrillating polyolefinic films which comprises:

- (a) preparing a mono-oriented base film by extrusion of a crystalline alpha-olefine polymer or copolymer or of a mixture thereof, cooling the film at 10°C - 70°C and subsequently longitudinally stretching it at 110°C - 30 150°C with a stretch ratio in the range 1 : 4 to 1 : 7; 30
- (b) extruding, onto one or both faces of the base film, a coating of the same polymer or copolymer or mixture used in the preparation of the base film, so that the thickness of the coating layer is from 1/6 to 1/10 of the thickness of the base film; and
- (c) cross-stretching the coated film at a temperature of 120°C to 160°C, using a stretch ratio in the range 1 35 : 6 to 1 : 10. 35

The polymers or copolymers or mixtures thereof suitable for use in the process of this invention both for the preparation of the base film and for its coating, are the crystalline polymers or copolymers of alpha-olefines, these generally being prepared with stereospecific catalysts. In particular, propylene having macro-molecules which are prevalently isotactic, and crystalline propylene-ethylene copolymers 40 prevalently containing propylene units, both of the block as well as of the random type, as well as polyethylene/polypropylene, polyethylene/crystalline propylene-ethylene copolymer, polypropylene/crystalline propylene-ethylene copolymer mixtures may be used.

The polymers and polymeric mixtures may be compounded with dulling agents, stabilizers, lubricants, fillers, and/or organic and inorganic pigments. 45

Preferably there are used polymers or polymeric mixtures with a melt index in the range 0.1 to 30.

The polyolefinic films obtainable by the process of this invention show good characteristics of thermoweldability, and good mechanical and aesthetic characteristics; they are non-fibrillating and display good resistance to sticking to the welding bars of automatic or semi-automatic machines used for the manufacture of containers, envelopes, small bags, vessels and in general articles intended for the packaging 50 industry.

The accompanying drawing shows in diagrammatic form an example of apparatus suitable for carrying out the process of this invention.

The drawing depicts an extruder (1) for the extrusion of the base film, a cooling unit (2), a pre-heating unit (3), a longitudinal stretching unit (4), the extrusion devices (5) for applying the olefine polymer on one or 55 both faces of the base film, and the transverse or cross stretching unit (6).

The measurement of the adhesion of the film to welding bars was made by measuring with an Instron dynamometer the force per surface unit ( $\text{g}/\text{cm}^2$ ) necessary for the detachment, from the welding elements, of a specimen connected to the dynamometer and subjected to welding under conditions similar to those of packaging machines normally used (temperatures between 130°C and 150°C, pressure 40 psi, time 1 second). 60

The fibrillability was evaluated by inspection with an optical microscope, after elongation on the Instron dynamometer.

The resistance of the weld was evaluated at 135°C - 150°C, with an Instron dynamometer, on superimposed and welded samples, under knurled bars, with a Sentinel type welder, for 1 second, under a pressure of 40 psi. 65

*The following examples illustrate how the invention may be carried into effect without limiting the wider scope.* 65

aspects thereof.

**EXAMPLE 1**

A thermoweldable and not fibrilling polypropylene film was prepared by film extrusion of a crystalline 5 polypropylene having prevailingly isotactic macromolecules, having a melt-index of 1, a residue from the heptane extraction of 97.2%, and an ash residue of 100 ppm, prepared by stereospecific polymerization of propylene. The procedure is schematically represented in the accompanying drawing.

The production of the film is achieved by the following successive operations:

- (a) preparation of the unstretched film by extrusion of the polypropylene;
- 10 (b) cooling down on rollers, to 40°C;
- (c) longitudinal stretching, at 140°C, with a stretch ratio of 1 : 5;
- (d) extrusion of polypropylene having the same characteristics as the base film, onto the mono-stretched film using a base film/coating film ratio of 8 : 1;
- (e) transverse stretching at 155°C, at a stretch ratio of 1 : 8;
- 15 (f) winding up.

The coated film thus obtained had the following characteristics:

- thickness of coating (in microns)	3	
- breaking load (kg/sq cm) transverse	2,800	
20 20 - breaking load (kg/sq cm) longitudinal	1,300	20
- elongation (%) transverse	45	
25 - elongation (%) longitudinal	180	
- adhesion (scotch-tape test) (%)	100	
- blocking at 43°C (ASTM D-1146/53)	200	
25 - transparency (ASTM D-1003/59T)	2	25
- glidability (static friction coefficient TMI)	0.5	
- resistance of weld (g/cm) at 145°C	70	
30 - resistance of weld (g/cm) at 150°C	250	
- fibrillability	none	
30 - adhesion to welding bars at 130°C	0	30
at 140°C	0	
at 150°C	0	

**EXAMPLE 2**

35 There was prepared a thermoweldable and non-fibrilling polypropylene film, by film extruding a crystalline polypropylene with prevailingly isotactic macromolecules having a melt-index of 2, a residue from the heptane extraction of 97.2%, and an ash residue of 100 ppm, prepared by stereospecific polymerization of propylene, the film being made by using the device schematically illustrated in the accompanying drawing.

40 The preparation of the film was achieved by the following successive operations:

- (a) preparation of a non-stretched film by extrusion of the polypropylene;
- (b) cooling on rollers, at 40°C;
- (c) stretching in a longitudinal direction at 140°C, with a stretch ratio of 1 : 5;
- (d) extrusion of polypropylene having the same characteristics as the base film, onto the mono-stretched film, using a base film/coating film ratio of 8 : 1;
- 45 (e) transverse stretching, at 155°C, at a stretch ratio of 1 : 8;
- (f) winding up.

The so-obtained coated film had the following characteristics:

50 - thickness of coating (in microns)	3	50
- breaking load (kg/sq cm) transverse	2,800	
55 - breaking load (kg/sq cm) longitudinal	1,300	
- elongation (%) transverse	45	
55 - elongation (%) longitudinal	180	
- adhesion (scotch-tape test) (%)	100	55
- blocking at 43°C (ASTM D-1146/53)	200	
- transparency (ASTM D-1003/59T)	2	
- glidability (coefficient of static friction TMI)	0.5	
- resistance of weld (g/cm) at 145°C	70	
60 - resistance of weld (g/cm) at 150°C	250	60
- fibrillability	none	
- adhesion to welding bars at 130°C	0	
at 140°C	0	
at 150°C	0	

**EXAMPLE 3**

There was prepared a thermoweldable and non-fibrillating polypropylene film, by film-extruding a crystalline polypropylene with prevailingly isotactic macromolecules, having a melt-index of 10, a residue from heptane extraction of 95%, and an ash residue of 100 ppm, prepared by stereospecific polymerization of propylene and by using the device schematically illustrated in the accompanying drawing.

The preparation of the film was achieved by the following successive operations:

- (a) preparation of an unstretched film by extrusion of polypropylene;
- (b) cooling on rollers at 40°C;
- (c) longitudinal stretching, at 140°C, at a stretch ratio of 1 : 5;
- 10 (d) extrusion of polypropylene, of the same characteristics of that of the base film, onto the mono-stretched film, using the base film/coating film ratio of 8 : 1;
- (e) transverse stretching at 155°C, at a stretch ratio of 1 : 8;
- (f) winding up.

The so-obtained coated film had the following characteristics:

		15
- thickness of the coating (microns)	3	
- breaking load (kg/sq cm) transverse	2,600	
longitudinal	1,200	
- elongation (%) transverse	50	
20       longitudinal	190	20
- adhesion (scotch-tape test) (%)	100	
- blocking at 43°C (ASTM D-1146/53)	200	
- transparency (ASTM D-1003/59T)	2	
- glidability (static friction coefficient TMI)	0.5	
25 - resistance of weld (g/cm) at 140°C	50	25
at 145°C	100	
at 150°C	250	
- fibrillability	none	
- adhesion to welding bars: at 130°C	0	
30       at 140°C	0	30
at 150°C	0	

**EXAMPLE 4**

A thermoweldable and non-fibrillating polypropylene film was prepared by film-extruding a crystalline polypropylene with prevailingly isotactic macromolecules, having a melt-index of 20, a residue from heptane extraction of 90%, an ash residue of 100 ppm, prepared by stereospecific polymerization of propylene, the film having been made by using the device schematically illustrated in the accompanying drawing.

The preparation of the film was achieved by means of the following successive operations:

- (a) preparation of an unstretched polypropylene film by extrusion;
- 40 (b) cooling on rollers at 40°C;
- (c) longitudinal stretching, at 140°C, at a stretch ratio of 1 : 5;
- (d) extrusion of polypropylene, of the same characteristics as that of the base film, onto the mono-stretched film, using a base film/coating film ratio of 8 : 1;
- (e) transverse stretching at 155°C, at a stretch ratio of 1 : 8;
- 45 (f) winding up.

The so-obtained coated film had the following characteristics:

		35
- thickness of the coating (in microns)	3	
- breaking load (kg/sq cm) transverse	2,600	
50       longitudinal	1,200	50
- elongation (%) transverse	50	
longitudinal	190	
- adhesion (scotch-tape test) (%)	100	
- blocking at 43°C (ASTM D-1146/53)	200	
55 - transparency (ASTM D-1103/59T)	2	55
- glidability (static friction coefficient TMI)	0.5	
- resistance of weld (g/cm) at 140°C	50	
at 145°C	250	
at 150°C	300	
60 - fibrillability	none	60
- adhesion to welding bars: at 130°C	0	
at 140°C	0	
at 150°C	0	

**EXAMPLE 5**

A thermoweldable and non-fibrilling polyolefine film was prepared by film-extruding a random propylene-ethylene copolymer, having a melt-index of 8; an ash residue of 78 ppm, and an ethylene content of 2.7%, prepared by copolymerization of the propylene/ethylene by means of a stereospecific catalyst, the 5 film having been made by using the device schematically illustrated in the accompanying drawing.

The preparation of the film was achieved by means of the following successive operations:

- (a) preparation of the unstretched film by extrusion of the copolymer;
- (b) cooling on rollers, at 40°C;
- (c) longitudinal stretching, at 125°C, with a stretch ratio of 1 : 5;
- (d) extrusion of a copolymer having the same characteristics of that of the base film, onto the 10 mono-stretched film, at a base film/coating film ratio of 8 : 1;
- (e) transverse stretching, at 145°C, at a stretch ratio of 1 : 8;
- (f) winding up.

The so-obtained coated film had the following characteristics:

15	- thickness of the coating (microns)	3	15
	- breaking load (kg/sq cm) transverse	2,300	
	longitudinal	1,000	
	- elongation (%) transverse	50	
20	longitudinal	210	20
	- adheslon (scotch-tape test) (%)	100	
	- blocking at 43°C (ASTM D-1146/53)	250	
	- transparency (ASTM D-1003/59T)	4	
	- glidability (static friction coefficient TMI)	0.5	
25	- resistance of weld (g/cm) at 135°C	200	25
	at 140°C	300	
	at 145°C	300	
	at 150°C	300	
	- fibrillability	none	
30	adhesion to welding bars: at 130°C	0	30
	at 140°C	0	

**CLAIMS**

35 1. A process for the preparation of thermoweldable, non-fibrilling polyolefine films which comprises: 35  
 (a) preparing a mono-oriented base film by extruding a crystalline alpha-olefine polymer or copolymer or a mixture thereof, cooling the film at 10°C - 70°C, and subsequently longitudinally stretching it at 110°C - 150°C with a stretch ratio in the range 1 : 4 to 1 : 7;  
 (b) extruding, onto one or both faces of the base film, a coating of the same polymer or copolymer or 40 mixture used in the preparation of the base film, so that the thickness of the coating is from 1/6 to 1/10 of the thickness of the base film; and  
 (c) cross-stretching the coating film at a temperature 120°C to 160°C, using a stretch ratio in the range 1 : 6 to 1 : 10.  
 2. A process according to claim 1, in which for the preparation of the base film and for coating the same 45 there is used a polymeric material selected from: isotactic polypropylene, propylene-ethylene crystalline copolymers with a predominant content of propylene, of the block copolymer or the random copolymer type, polyethylene-crystalline polypropylene mixtures, polyethylene/crystalline propylene-ethylene copolymers and polypropylene/crystalline propylene-copolymer mixtures.  
 3. A process according to claim 1 or 2 in which the polymeric material used has a melt-index of 0.1 to 30.  
 50 4. A process according to claim 1, substantially as described in any of the foregoing examples.  
 5. Thermoweldable, non-fibrilling polyolefine films when prepared by a process as set forth in any of the foregoing claims.